Work Order ID 105939 -Tuesday, August 27, 2013 7:29:25 AM

X \$108939

105939

Page 1

N900040100 Accept Setup Start D3235-1 Item ID: Revision ID: Item Name: Mounting Lug Start Qty: 125.00 Cust Item ID: 8/27/2013 Start Date: Required Date: 9/16/2013 Req'd Qty: 125.00 Customer: Reference: Run Start 13/08/2) Tooling: Process Plan: Date: Date: Approvals: Stop SPC (Y/N): Date: QC: Date: Tool # Plan Accept Reject Reject Insp. Set Up/ Tool ID Operation Sequence ID/ Qty Qty Number Stamp Code Run Hours Work Center ID Description Revision Nbr Draw Nbr D3235 Rev A 0.00 110 Outsource process - Machining (L/13/08/27 125 HAAS CNC VERTICAL MACHINING # *110* 0.00 Outsource5 Issue P/O to Metec: Outsource process - Machining Machine as per dwg C of C is required Receive & Inspect for Damage & Mat'l Certs 0.00 120 *120* 0.00 Packaging Memo Ensure C of C is attach Packaging DAS 0.00 QC6- Inspect dimensions to drawing 27 130 *130* QC Memo Quality Control

See June NCR 13-5077

| NCR: | (Yes Y | No |
|------|--------|----|
| | | |

WORK ORDER NON-CONFORMANCE / UPDATE

| DQA: Date: | 14 | 101 | 62 | |
|------------|----|-----|----|--|
| | | | | |

| Mary America Z. | _ | | | Sall I | | | | | | QA Closed: | Date | : 13/12/3 |
|--|---|------------|---|--|--|---|---|--|--|-------------------------------|---|---------------------------|
| Work Orde | r: \(| 559 | 39 | | DISPOSITION | | | 1 | AGAINST DE | PARTMENT | /PROCESS | |
| 70 L 1 | a. <u> </u> | | | | Rework Scrap Use-as-is Work Order Update | | 1 | Skid-tube Machining noforming Large Fab | Crosstube Small Fab Finishing Composite | | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other |
| Root | | | | Descri | iption of work order update | ,lı | nitial | Act | tion | Sign & | | |
| Cause | Date | Step | Qty | 1111 | or Non-conformance | Chi | ief Eng | Descr | ription | Date | Verification | QC Inspector |
| Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved | perator Aterial etup Other Process Upplier Praining | | too to be a sounder coat by supplier not shough we are so at at | < | respect to supplies for a possible could | | | 27 9489 R/12/03 | 13112102 13112102 | DAS 29 9-89 13 12 02 | | |
| | | | HE H | | | UL | T CATE | GORY | | | | and the second |
| Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence | | | | General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish | | Mainte Mainte Mislabe Misrea Offset Out of Out of | ion Incomplete cions Incomplete/lenance eled d Calibration Sequence | Unclear | Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss, | ct issing Wrong | Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other | |
| | Wave/Tw | vist in Tu | oe e | 1 | Folio | | Outside | Dimensions | | | | |

Tuesday, August 27, 2013 7:29:25 AM

105939

Page 2

N900040100 Accept Setup Start Item ID: D3235-1 Revision ID: Mounting Lug Item Name: *125* Start Oty: 125.00 8/27/2013 Cust Item ID: Start Date: Required Date: 9/16/2013 Reg'd Oty: 125.00 *125* Customer: Reference: Run Start Date: Tooling: Process Plan: Date: Approvals: Stop Date: Date: SPC (Y/N): OC: Tool # Plan Reject Reject Insp. Set Up/ Tool ID Accept Sequence ID/ Operation Number Stamp Code Qty Qty Work Center ID Description Run Hours Chemical Conversion Coat per OSI005 4.1 0.00 140 ATG P10: 21082 CX 13/03/27 *140* 0.00 HandFinish Memo Hand Finishing OC3-Inspect Part Finish 0.00 150 CX13/11/27 *150* 0.00 QC Memo Quality Control White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum 0.00 160 (Z 13/08/2) *160* 0.00 Powdercoat Memo

M126125 A.T.C- P/0: 21082

Powder Coating

START TIME: OVEN TEMPERATURE:

FINISH TIME:

| VCR: | Yes / No | WORK ORDER NON | 1-COL |
|------|----------|----------------|-------|

| | DQA: | Date: | | 30 |
|---------------------|---|-------|-----|----|
| ONFORMANCE / UPDATE | *************************************** | | 120 | 雅二 |

| A description | - Inc | | | | | | | | | | QA Closed: | Date: | |
|------------------------|-------|--------------------------|-----------|---------------|--------------|---|-----|-----------------|-------------------|------------|--|---------------|--------------------|
| Work Orde | r: | | | | | DISPOSITION | | | | AGAINST DE | PARTMENT | /PROCESS | |
| | | | 171 | HA I | | Rework | | 0 | Skid-tube | Crosstube | | Water Jet | Engineering |
| Part N | 0. | | Charles | 1991 | I BEE | Scrap | | | Machining | Small Fab | | d. Eng. Coor. | Quality |
| | | | | | | Use-as-is | | Thern | noforming | Finishing | Rec/Stor | re/Packaging | Other |
| NCR N | 0 | | | | | Work Order Update | | | Large Fab | Composite | 2 | Supplier | |
| | _ | | | | D | | | 201-1 | | | C: 0 | <u></u> | |
| Root | | Date | Chan | Qty | Des | cription of work order update or Non-conformance | | nitial | 0.400 | tion | Sign & Date | Verification | QC Inspector |
| Cause | + | Date | Step | Qty | BEET B | or Non-conformance | Cn | ief Eng | Descr | ription | Date | verilication | QC Inspector |
| Doc/Data Equip/Tooling | - | | | | The state of | | | *9 | 100 | | | | 45 |
| Operator Operator | | | | | | | | | | | | = | |
| Material | | | | 46 | | | 1 | | | | 0 | E | 40.0 |
| Setup | | | | | | | | | 100 | | | | |
| Other | | | | - 3 | 6 150 4 | | | | | | | | |
| Process | | | | 1 5 | | | 4 | | | | | | |
| Supplier | | | | 145 | | | | | | | | | |
| Training | | | | | | | 1 | | | | | | |
| Unapproved | | | | To the second | | | | 31 | | | | | |
| | | | | | 15.4 | F F | AUL | T CATE | GORY | | | | N N |
| Landin | ig G | iear | | | | General | _ | | | _ | 1 | | |
| | _ | Bending | | | | Bend | | Grain | | | Ovalized | | Pressure/Forced |
| | _ | Centre No | ot Concer | ntricto | O/S | BOM/Route | | Hardwa | | | Over/Under | | Temperature/Cure |
| | - | Cracks | | | | Broken/Damaged | - | Charle Charles | ion Incomplete | – | Part Incorred | | Weld |
| 1 mm-4 | _ | Crushed/ | Crimped | | | Burrs | - | 1 | ions Incomplete/I | Unclear | Part Lost/Mi | ssing | Wrong Stock Pulled |
| | | Cuffs | | | | Contamination | | Mainte | | | Part Moved | V | |
| | | Heat Trea | | Tille | | Countersink Cut Too Short | | Mislabe | | - | Positioned V Power Loss/ | | Other |
| | _ | Inspection Ripples in | | MOG | | Drill Holes | - | Offset | , | | I ower coss/ | Juige | Total Line |
| | | Terque W | | vtrusio | 10 | Drawing | - | | Calibration | | | | 300 |
| | - | Turning S | | | No. | Finish | - | Out of Sequence | | | | A.S. | |
| | - | Wave/Tw | | | | Folio | | | Dimensions | | P. Commission of the Commissio | | |

H:/FORMS/Quality Assurance\approved QA7NERWO Rev G

Work Order ID 105939 Tuesday, August 27, 2013 7:29:25 AM D3235-1 Item ID: Revision ID: Mounting Lug Item Name: Start Qty: 125.00 8/27/2013 Start Date: Reg'd Qty: 125.00 Required Date: 9/16/2013 Reference: Approvals: Process Plan: QC: Date: Sequence ID/ Operation Description Work Center ID Qd3- Inspect Part Finish 170 *170* OC Memo Quality Control

N900040100 Accept

Setup Start

Cust Item ID:

Customer:

Date:

Tooling:

SPC (Y/N):

125

Date:

Date:

Start Run

Stop

Set Up/ Run Hours

27

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

180

120 Packaging

Packaging

Identify as per dwg & Stock Location: 5T470

0.00

Memo

0.00

123 × 28 13-12-17

190

190

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

2m 13/12/18 MF 12/18

| 17 1 1 1 1 | | | | | | | | | | Dun. | Date. | | |
|---|------------------|---------------------------|----------|--|---|------------------|---|--------------------------|---|---|---------------------------|--------------------------|--|
| NCR: Ye | s / No | | | | WORK ORDER NON-C | 100 | VFOR | MANCE / UPDATE | | | | | |
| | | | | Military III | | _ | | | | QA Closed: | Date: | | |
| Work Order | | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | |
| Part No. | | | | Rework Scrap Use-as-is Work Order Update | Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite | | | | | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other | | |
| Reot | | | | Descri | ption of work order update | 1 | nitial | Action | | Sign & | | | |
| Cause | Date | Date Step Qty or Non-co | | | or Non-conformance | Ch | ief Eng | Description | | Date | Verification | QC Inspector | |
| oc/Data quip/Tooling perator Material etup other rocess upplier raining | Date Step Qty or | | | | | | | | | | | | |
| | 2112 | | | 100 | F | AUL | T CATE | GORY | | | | | |
| Landing | | | | | General | | 1 | | _ | 1 | | 1 | |
| | Bending | | | | Bend | - | Grain | | H | Ovalized | _ | Pressure/Forced | |
| | | lot Conce | ntric to | O/S | BOM/Route | - | Hardwa | | - | Over/Under | | Temperature/Cure Weld | |
| | Cracks | | | | Broken/Damaged | - | - | ion Incomplete | - | Part Incorred | _ | Wrong Stock Pulled | |
| 2 2 2 2 | _ | /Crimped | | | Burrs | - | - | tions Incomplete/Unclear | - | Part Lost/Mi Part Moved | Issing | Jwrong Stock Pulled | |
| | | Cuffs | | | Contamination | - | 200000000000000000000000000000000000000 | enance | - | Positioned V | Vrong | | |
| | Heat Treat | | | | Countersink | - | Mislabe | | - | Power Loss/ | | Other | |
| 1 119 | | | | | Cut Too Short Drill Holes | - | Offset | u | | I owel ross/ | Juige | Other | |
| | | | | - 0000 | - | CITAL CONTROL OF | Calibration | | - | | | | |
| - | | | | | Drawing | - | - | | | | | | |
| 10 10 | Turning | Turning Sequence Finish | | | IFINISh | | TOUT OF | Sequence | | | | | |

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Page 1

Tuesday, August 27, 2013 7:29:25 AM

Work Order ID:

105939

Parent Item:

D3235-1

Parent Item Name:

Mounting Lug

Start Date: 8/27/2013

Required Date: 9/16/2013

Start Qty: 125.00

Required Qty: 125.00

Comments:

IPP A04.04.19New issueKJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--|----------------|-------------|--------------|---------------|----------------|--------|
| D2423 | | Manufactured | No | | | | f | 268.9220 | | 8.986842 | 2/3/1 | 0/25 | |
| Lug Extrusion | | | | | | 91011-320011 | ************************************** | | | | 00101 | - | |
| | | | | Location | | Loc Qty | Lo | c Code | | | | | |
| | | | | MAT006 | | 221.5 | | | | - | | | |
| | | | | 8795 | 3 | 221.5 | | | 7 | .00 | | | |
| | | | | Metec | | 47.422 | | | | | | | |
| | | | | 9355 | 1 | 47.422 | | | | | - | | |
| D3235-1P | | Purchased | No | | | | Each | 0.0000 | | 125 | R/3/4, | 1.1 | 122 |
| lug | | | | | | | | | | / | 73/11 | 38 (| 1) |

| NO | CR: | Yes | / No |
|----|-----------|-----|------|
| | M(1) (9 M | | |

WORK ORDER NON-CONFORMANCE / UPDATE

| DQA: | Date: | |
|------|-------|--|
| | | |

| | 3 / 140 | | | | WOME ONDER HORE | .01 | vi Oiti | VIAITEL / OI L |)/(IE | QA Closed | : Dat | te: | |
|---------------------------------|------------|----------|----------|----------|--------------------------------|-----|--------------|----------------------------|------------------------|-------------|-----------------------------|---------------------------|------|
| Work Order | | | | | DISPOSITION | | | | AGAINST D | EPARTMEN | T/PROCESS | | |
| Part No | 0, | | | | Rework Scrap | | 1 | Skid-tube Machining | Crosstube Small Fab | Pr | Water Jet od. Eng. Coor. | Engineering Quality Other | |
| NCR No | D | | | | Use-as-is Work Order Update |] | SCOOLS CONT. | Large Fab | Finishing Composite | Rec/sti | ore/Packaging Supplier | Other | 1 |
| Root | | | | Descr | iption of work order update | 1 | nitial | Act | ion | Sign & | | | |
| Cause | Date | Step | Qty | | or Non-conformance | Ch | ief Eng | Descr | iption | Date | Verification | QC Inspecto | r |
| Doc/Data Equip/Tooling Operator | | | | | | | | 1 | | | | | |
| Material | | 333 | | | | | | | | | | - 74 | |
| setup | | - 100 | l i | | | | | | | | | - 8 | |
| Other | | | | | | | | | | | | 4 | |
| Process | | | | | | | | | | | | - 第 | |
| Supplier | | | The S | | | | | | | | | | |
| Training | | 111111 | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | 1.30 | ile. |
| | HP. | | HEE | | F | AUL | T CATE | GORY | | | | -70 | EN. |
| Landin | g Gear | | | | General | | | | | _ | | | |
| | Bending | | | | Bend | | Grain | | _ | Ovalized | | Pressure/Forced | |
| | Centre No | ot Conce | ntric to | O/S _ | BOM/Route | | Hardwa | | | _ | er tolerance | Temperature/Cur | е |
| | Cracks | | | | Broken/Damaged | | 4 0 | ion Incomplete | | Part Incorr | | Weld | |
| | Crushed/ | Crimped | | | Burrs | | - | tions Incomplete/L | Inclear | Part Lost/N | | Wrong Stock Pull | ed |
| 1 22 | Cuffs | | | | Contamination | | Mainte | | - | Part Move | | | |
| Nuise I | Heat Trea | | | | Countersink | | Mislabe | | | Positioned | | | |
| Barrier Land | Inspectio | | Tulie | | Cut Too Short | | Misread | d | L | Power Los | s/Surge | Other | |
| | Ripples in | | | | Drill Holes | | Offset | English (Arterial Property | | | | 8.77 | |
| | Torque V | | | n _ | Drawing | - | - | Calibration | | | | 152 | att. |
| | Turning S | equence | | STATE OF | Finish | | Out of | Sequence | | | | - 3 | 芸二 |

Outside Dimensions

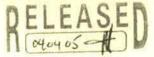
Wave/Twist in Tube

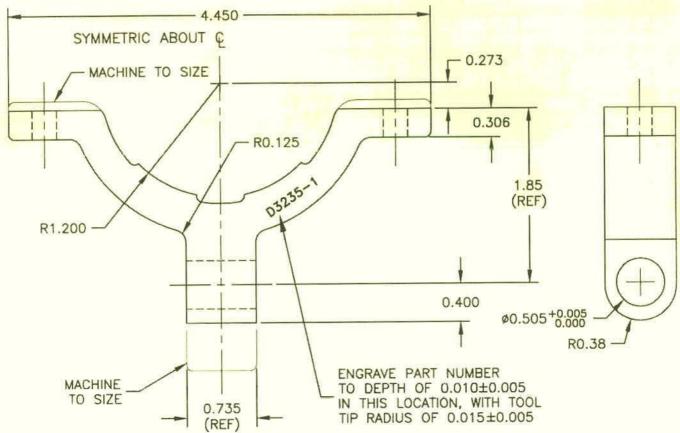
Folio

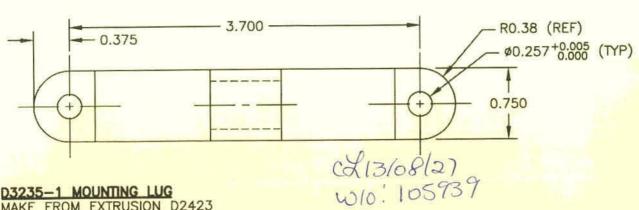




| 1 | DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
|---|----------|----------|--|
| 1 | CHECKED | APPROVED | DRAWING NO. REV. |
| | A | 1 | D3235 SHEET 1 OF |
| | DATE | | TITLE SCAL |
| | 04.03.02 | | MOUNTING LUG 1 |
| | Δ | 04 03 02 | NEW ISSUE |







D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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| | | 200 |
|-------|-----------|-----|
| NCR | res / | No |
| 14011 | 100 / | 110 |

WORK ORDER NON-CONFORMANCE / UPDATE

| DQA: | Date: | |
|-----------|-------|------|
| | | 17.3 |
| A Closed: | Date: | |

| <u>-</u> | QA Closed. Date. | | | | | | | | | | | | |
|---------------|------------------|------------|------------|------------|------|----------------------------|----------|------------------------------------|------------------|------------|---|---------------|-----------------------|
| Work Orde | r: _ | | | | | DISPOSITION | | | | AGAINST DE | PARTMENT | | |
| PAN A | | | | | | Rework | | | Skid-tube | Crosstube | | Water Jet | Erigineering |
| Part N | 0 | | | | | Scrap | - 1 | | Machining | Small Fab | L TAN 338 | d. Eng. Coor. | Quality |
| 1 | | | | | | Use-as-is | | | oforming | Finishing | Rec/Star | e/Packaging | Other |
| NCR N | 0 | | | | | Work Order Update | | | Large Fab | Composite | | Supplier | |
| 234 | | | | | | | _ | *** (] | - | | C: 0 | | |
| Root | - | | 27 | 400 | | ption of work order update | | nitial | | tion | Sign & | Varification | OCIncuestor |
| Cause | | Date | Step | Qty | | or Non-conformance | Chi | ef Eng | Desci | ription | Date | Verification | QC Inspector |
| Doc/Data | - | | | | | | | | | | 111 142 1416 | | |
| Equip/Tooling | - | | | | | | | | | | Casal S | | |
| Operator | - | | | | | | | - 1 | | | | | |
| Material | 5 | | | | | | | | | | | | |
| Setup | - | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | |
| Process | - | | | | | | | | | | | | |
| Supplier | 2 | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | |
| Unapproved | | | | | | | | CATE | CORV | 1.0 HV2.5 | | | |
| | | | | | | | AUL | CATE | JORY | 1733 | rest to | | |
| Landir | | | | | | General | | Grain | | 100 | Ovalized | Г | Pressure/Forced |
| 属" | _ | Bending | | | 0.10 | Bend | - | | | 5 | Over/Under | toloranco | Temperature/Cure |
| | _ | Centre No | t Concer | itric to | 0/5 | BOM/Route | - | Hardwa | | | Part Incorrec | | Weld |
| | $\overline{}$ | Cracks | n.t | | | Broken/Damaged | \vdash | | on Incomplete | Unclear | Part Lost/Mi | - | Wrong Stock Pulled |
| | - | Crushed/0 | rimped | | | Burrs | - | | ions Incomplete/ | Unclear | Part Moved | SSILIR | |
| | - | Cuffs | | | | Contamination | - | Mainte | | - 200 | Positionec V | Vrong | |
| | | Heat Trea | | T. b. | _ | Countersink | - | Mislabe | | 1 to 1 | Positioned v | | Other |
| | - | Inspection | | Tube | | Cut Too Short | - | Misread | 1 | | Trower mæ/ | Suige | Other |
| | | Ripples in | | -004000000 | _ | Drill Holes | - | Offset | alibeation | | in Self- | | |
| | | Torque W | | | n | Drawing | - | Out of Calibration | | | | | |
| | | Turning S | | | | Finish | - | Out of Sequence Outside Dimensions | | | Aller Control | | |
| | - | Wave/Tw | ist in Tut | oe | | Folio | \Box | Outside | Dimensions | | NP TO THE REAL PROPERTY. | | till a company of the |



A.T.G. INDUSTRIES INC. 731 INDUSTRIELLE STREET ROCKLAND, ON K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 906958

Date: 28-Nov-13

To

DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 Canada Ship To

CHANTAL LAVOIE
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

Canada

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

| erms | | Ship Via | | | | | | | |
|----------|---|--|-----------------|--|--|--|--|--|--|
| | | | 1000 | | | | | | |
| Quantity | Description | | | | | | | | |
| | PLEASE REFERENCE THE PACI SHIPMENT. IF YOU HAVE ANY QUESTIONS, | CK LIST NUMBER ON ALL CORRESPONDENCE TO THIS , PLEASE CALL AT (613) 446-4544. | | | | | | | |
| 248 | Part: D2230-3P | | Rev: G | | | | | | |
| ea | MOUNTING LUG | | | | | | | | |
| | Job: 14996 | PO: PO21082 | Line: 1 | | | | | | |
| 123 | Part: D3235-1P | | Rev: A | | | | | | |
| ea | MOUNTING LUG | | | | | | | | |
| 2 | Job: 14997 | PO: PO21082 | Line: 2 | | | | | | |
| 14 | Part: D3910-3P | | Rev: B | | | | | | |
| | X-TUBE LUG | | | | | | | | |
| | Job: 14998 | PO: PO21082 | Line: 3 | | | | | | |
| | A.T.G. INDUSTRIES INC. CERTIF CONFORMANCE WITH THE REC REFERENCED IN THE ABOVE PI | ICATE OF CONFORMANCE TES THAT ALL ITEMS IN THIS SECUREMENTS, SPECIFICATIONS | S, AND DRAWINGS | | | | | | |

